WHITE
SUPERLOCK
OWNERS WORKBOOK
2000 ATS

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Education Department
White Sewing Machine Company
11760 Berea Road
Cleveland OH 44111

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INTRODUCTION

Welcome to the world of easy, speed sewing. The White Superlock was designed with the home sewer in mind. It is simple to thread, simple to change from regular sewing to specialty sewing, such as flatlock and rolled edge. The automatic thread tension release will help you in easy removal of your projects and creative sewing. This workbook is compiled in a method so you will thoroughly understand the machine and its potential. After following these instructions, you will marvel at how easy your new White Superlock is to operate.

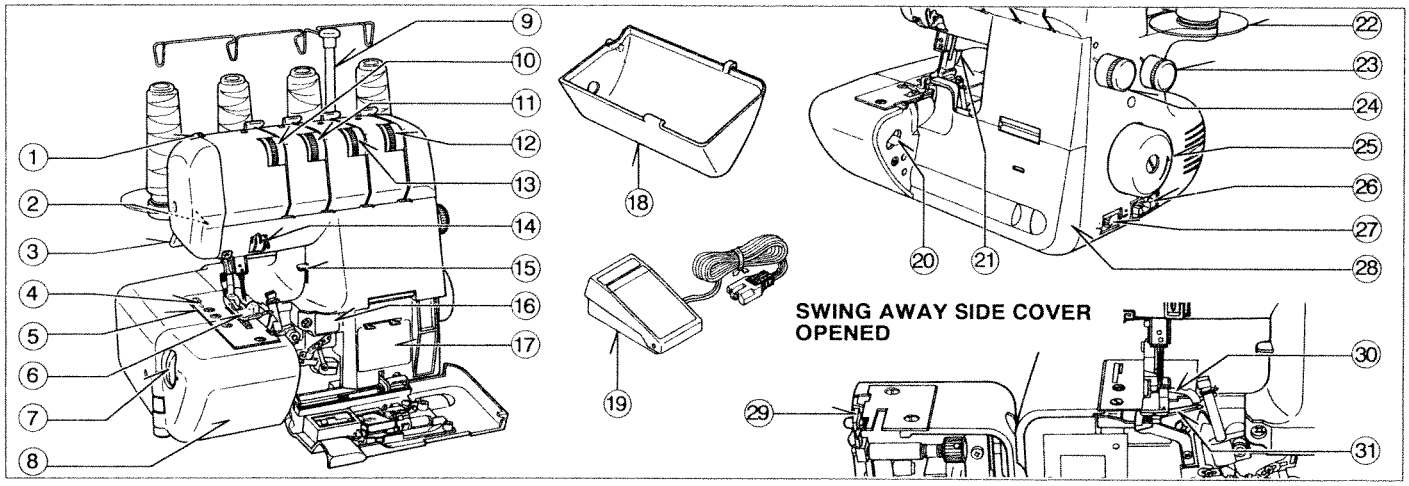
SECTION I

KNOW YOUR MACHINE - MODEL 2000 ATS

Top of the line Superlock model 2000 ATS is a 2/3/4 thread serger with adjustable cutting width, built in rolled edge and differential feed. It is capable of two, three or four thread sewing plus many decorative and specialty applications. A section of this workbook outlines many different techniques, specialty feet, and simple quick projects for you to try on your new Superlock.

1. KNOWING YOUR MACHINE

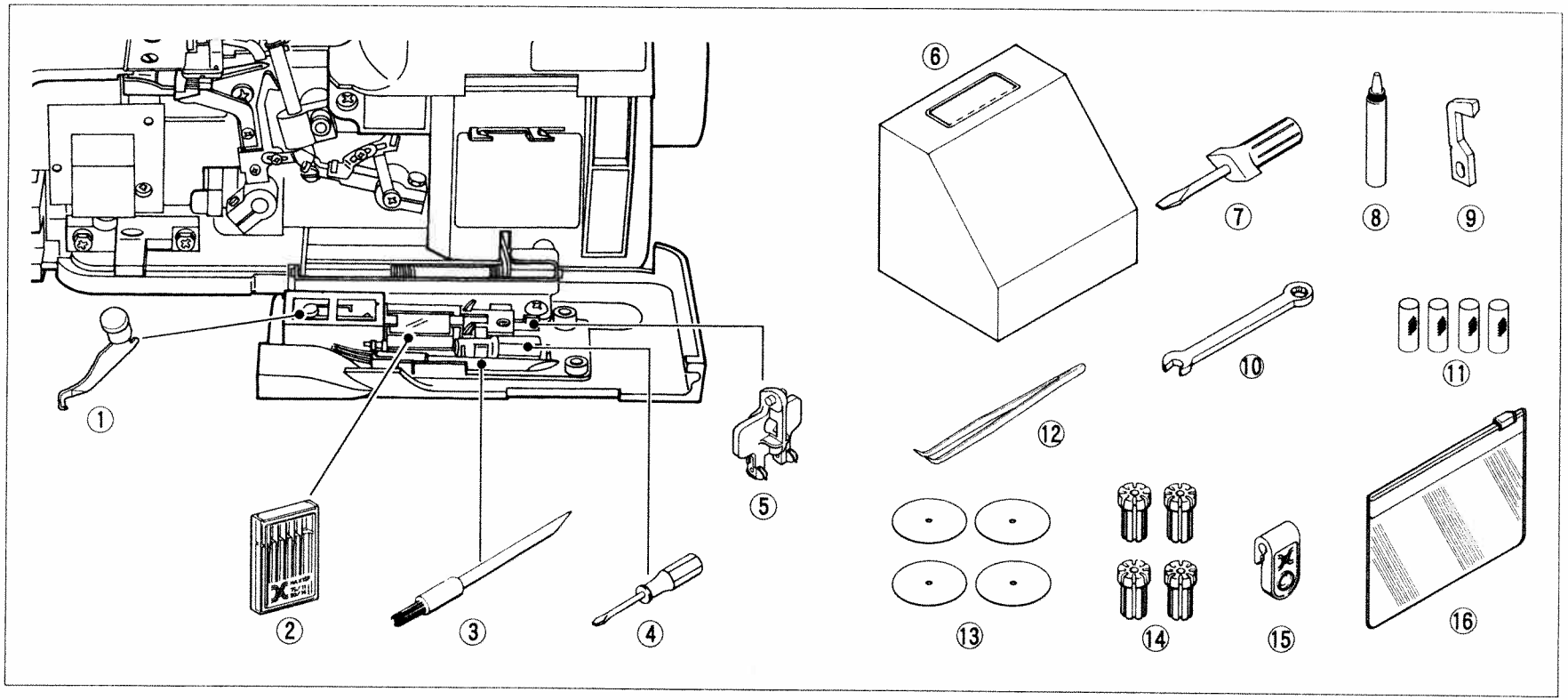
IDENTIFICATION CHART



1. Foot pressure regulator
2. Sewing light
3. Presser foot lift lever
4. Thread cutter (Model 2000 only)
5. Needle plate
6. Presser foot
7. Overedge cutting width dial
8. Swing away side cover
9. Thread guide pole
10. Left needle thread tension dial
11. Right needle thread tension dial
12. Lower looper thread tension dial
13. Upper looper thread tension dial
14. Needle thread guides
15. Thread cutter lever (Model 2000 only)
16. Two thread convertor instruction (Model 2000 only)
17. Threading chart
18. Waste tray (Model 2000 only)
19. Foot control
20. Release lever side cover
21. Foot release lever
22. Thread extension plate
23. Differential feed control dial
24. Stitch length dial
25. Hand wheel
26. Plug connector socket
27. Light and power switch
28. Front cover
29. Moving cutter
30. Upper looper
31. Lower looper

ACCESSORIES

All parts listed may be obtained from your nearest dealer.



1. Two-thread convertor (Model 2000 only)
2. Needle set
3. Brush
4. Screwdriver (small)
5. Needle threader
6. Machine cover
7. Screwdriver (large)
8. Oiler
9. Moving cutter
10. Spanner
11. Thread net
12. Tweezers
13. Thread extension plate
14. Cone holder
15. Cord guide
16. Accessory bag

*Only Model 2000 has storage of accessories at the back of front cover.

SUPERLOCK SET UP & MAINTENANCE

1. Set your Superlock on a sturdy, flat surface.

2. Your Superlock has been thoroughly oiled at the factory so be sure to wipe the needle and bed plate areas carefully before sewing a garment. Practice on a scrap of fabric so any surplus oil is absorbed.

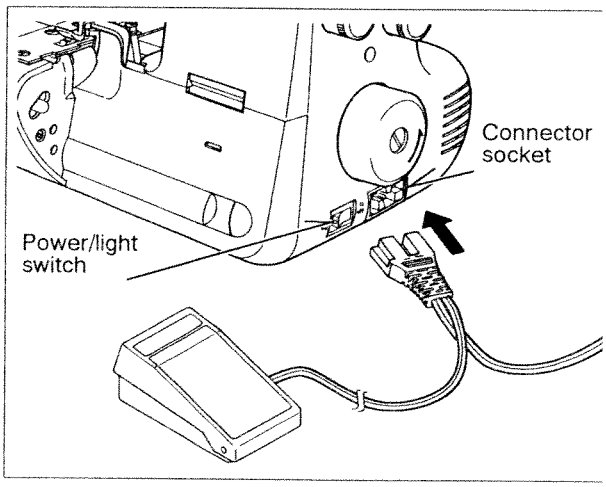
3. FOOT CONTROL
   Push foot control plug into the connector socket at the bottom right side of your Superlock.

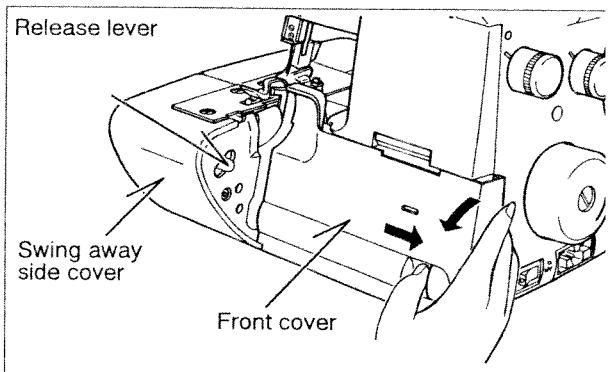
4. POWER/LIGHT SWITCH
   To operate your machine, turn the power switch on. It is located at the bottom right hand side. The same switch controls both power and light. If leaving your Superlock unattended, turn switch off.

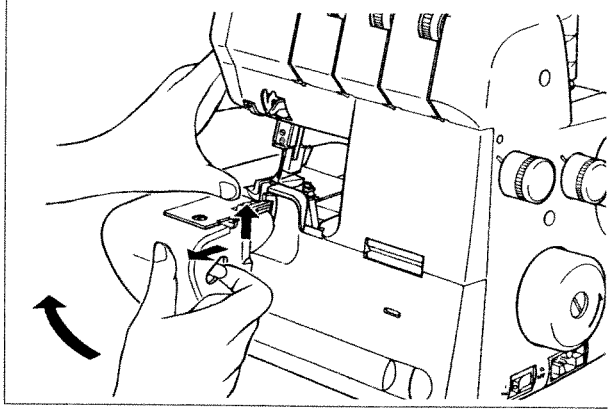
5. OPENING FRONT COVER
   To open front cover, push part B of cutter cover to right and pull the cover down toward you. To open the side cover, press down on the silver knob located to the inside of the side cover, and swing the lower left portion of the Superlock to the left.

6. CLOSING FRONT COVER
   Push part B and lower left cover toward the center of the front to close it.
   Note: Always close front cover when sewing.

7. OPENING SWING-AWAY SIDE COVER
   To open side cover, pull the release lever toward you with your right hand and swing out to left.
   NOTE: Always close side cover when sewing.



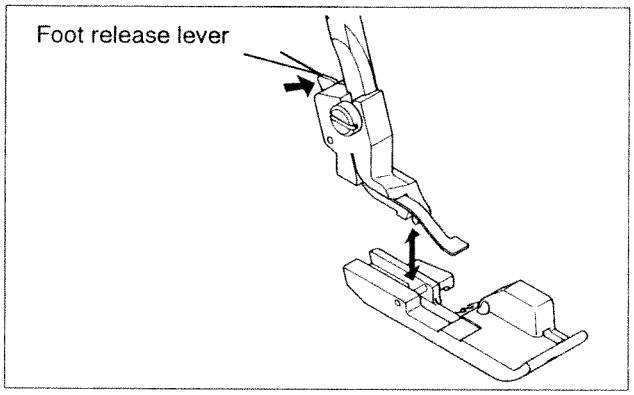




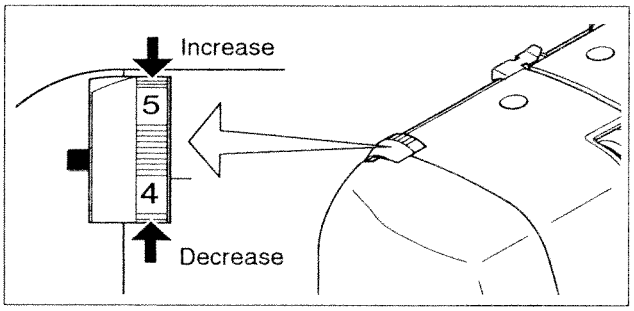
8. HANDWHEEL
Always turn handwheel toward you.

9. PRESSER FOOT LIFT
Raise the presser foot lift to lift up the presser foot.

10. CHANGING PRESSER FOOT
Switch off your Superlock.
Raise presser foot.
Raise needles to their highest position by turning handwheel toward you.
Push lever A and foot will come off.
Position the new foot with pin right under the groove of the ankle. Lower presser foot lift so that holder catches the presser foot.

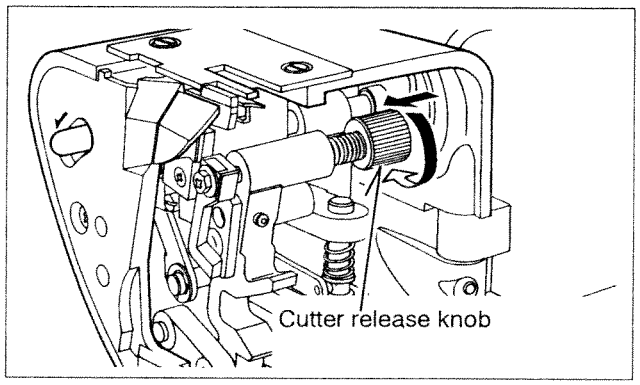


11. ADJUSTMENT OF THE PRESSER FOOT PRESSURE
The presser foot pressure is pre-adjusted for materials of medium thickness. Adjustment is necessary only when you work on very thin or very thick materials. Accordingly, sew thinner materials with less pressure (2 - 3) and thicker materials with more pressure (4 - 5). Increase the pressure of the presser foot by turning the dial to the desired number.



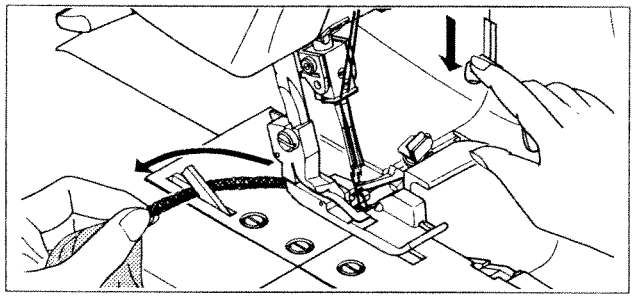
12. DISENGAGING UPPER CUTTER

To lower the upper cutter, open the left front cover and turn the cutter knob toward you until the cutter is all the way in the down position. BE SURE TO PUT CUTTER BACK UP BEFORE SEWING.



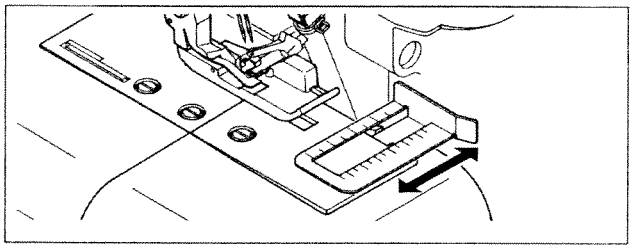
13. EXCLUSIVE BUILT-IN THREAD CUTTER

The built-in scissor conveniently cuts your thread tail simply by pressing down on the lever as illustrated, then releasing to cut.



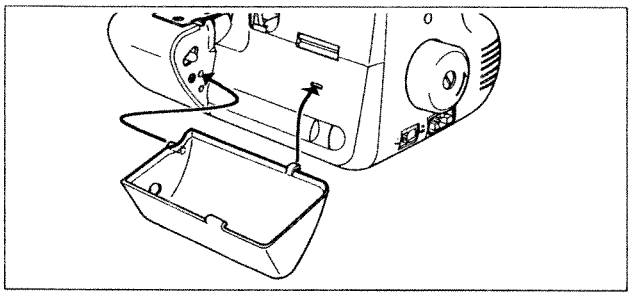
14. ADJUSTABLE FABRIC GUIDE

The adjustable seam guide can slide to the left or right as needed to keep fabric straight while serging seams.



15. WASTE TRAY

Place the large waste tray on the front of your Superlock by hooking over the slot on the right front cover and inserting the peg on the left into the hole on the side cover, as illustrated.



16. OILING

Lubrication is not required often for this machine since the important parts are all made of a special oil impregnated sintered metal. You will want to occasionally put one or two drops of oil on moving metal parts will increase durability.

17. CLEANING

First disconnect machine from power supply by removing plug from the electric outlet. Open front cover and side cover (see pg. 3). Using the brush provided, remove all the dust and lint that has accumulated. Remember to also clean between the cutters often.

18. STORAGE

When the machine is not in use, disconnect it from the power supply by removing plug from the electric outlet.

Using the vinyl cover provided, cover your machine when not in use.

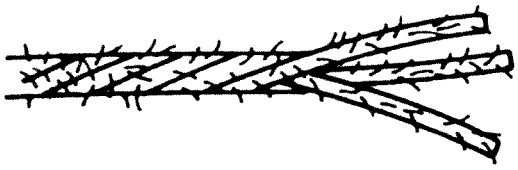
HINTS FOR SUCCESSFUL STITCHING

An understanding of the following variables will make your Superlock run smoothly and your work will look professional. Before sewing, always test the compatibility of your fabric, thread, pressure, stitch length, and tension.

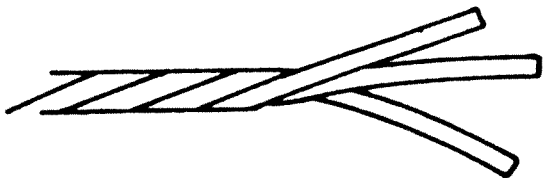
Thread Selection

When selecting the proper thread, choose one that is compatible with the fashion and the fabric. Polyester threads (or polyester based) are most commonly used for general sewing purposes. Threads of different fibers (cotton, rayon, silk, etc.) are available for special sewing.

Quality is a very important consideration when selecting a thread. A thread of poor quality will result in operating and stitching problems on any type of sewing machine. Synthetic threads are made by twisting filaments together. Lower quality synthetic threads are made by twisting short, leftover filaments of polyester together. The result is a "hairy" appearance and a weaker thread. Better quality threads are made by twisting long continuous filaments together. This thread is stronger and smoother, thus fewer operating problems will occur. Brand name and price do not necessarily represent quality in a thread. The only true test of thread quality is close examination.



Poor Quality



Good Quality

A variety of threads are available for overlocks. They may be of cotton, cotton-wrapped polyester, polyester or nylon (Wooly Nylon®). These are most often put up on cones or tubes. Threads for the overlock are generally finer and lighter in weight than standard sewing machine thread. This is because of the large amount of thread that builds up in an overlock seam. Finer thread makes for a less bulky seam. Your Superlock will handle thread on cones or spools. Many decorative threads will be discussed later in this workbook.

NEEDLE REPLACEMENT

Replace needles in the following way:

1. Bring needles to their highest position by turning handwheel towards you.

2. Lower presser foot.

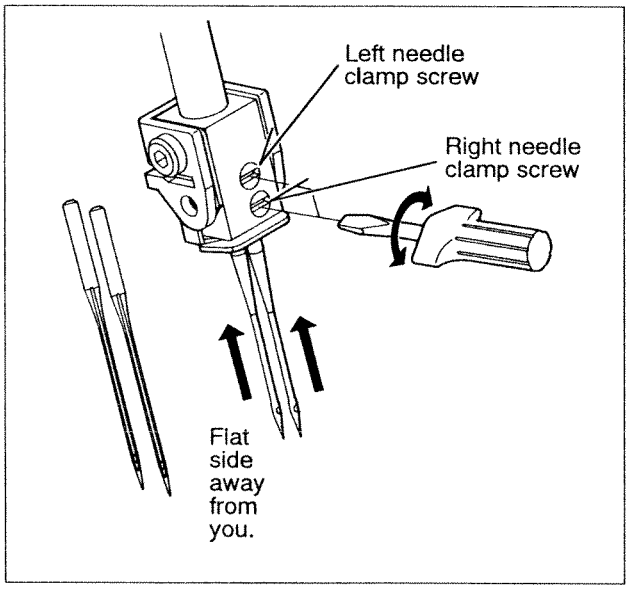
3. Open front cover: the screwdriver and needles are located inside the handy storage area.

4. When replacing right needle, loosen right needle clamp screw, marked "R", and remove needle. Be sure to store extra loose needles in needle cushion.

   To replace left needle, loosen left needle clamp screw.

5. With the flat side away from you, insert the new needle into groove of needle bar as far as it will go. Use an Organ brand HA x 1SP. These are standard needles used for home sewing.

   Change needles after each garment for best results.



NEEDLES, THREAD & FABRIC CHART

Needles

Proper needles are important when using your White Superlock. A standard sewing machine needle of good quality, Organ brand HA X 1SP, can be used on your Superlock. Change needles often for best results.

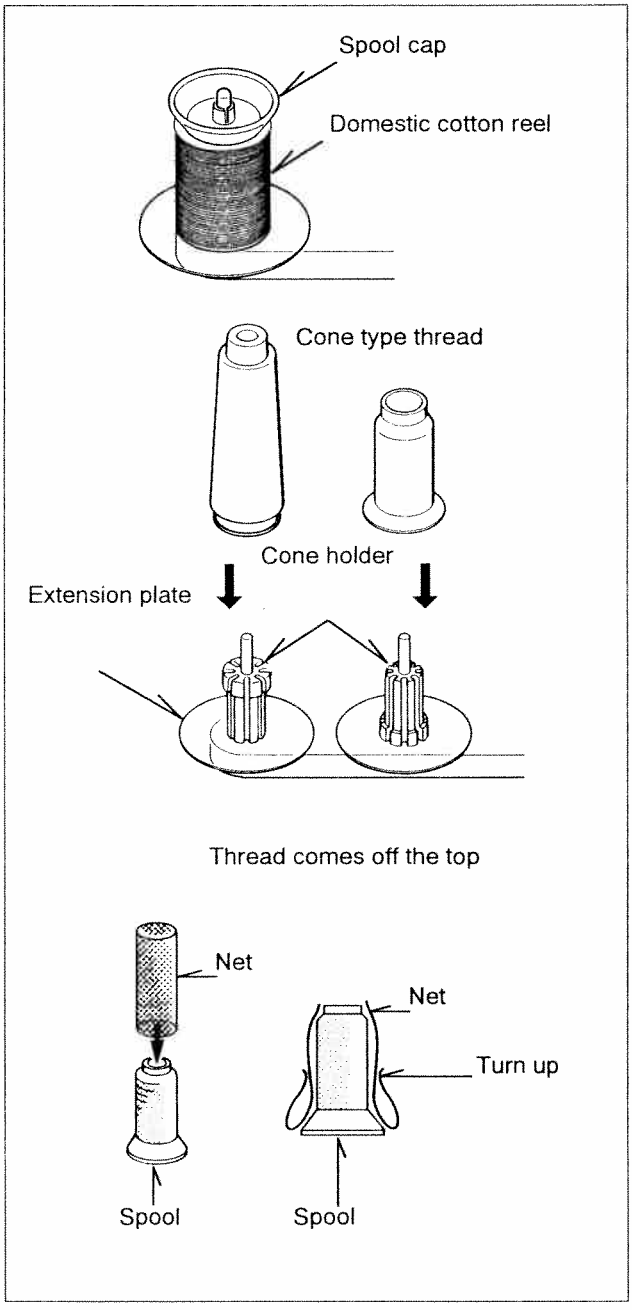
Caution: Do not used banded needles (i.e., yellow band) on your White Superlock. These can cause skipped stitches and possibly bend or break needles or damage loopers.

Threads

Any good quality cotton, polyester, silk, synthetic threads, etc., can be used on your Superlock. Wooly Nylon®, a stretchy, yarn-like thread, is recommended in upper and lower loopers for rolled edge and lingerie sewing.

Fabric		Thread	Needle
COTTON LINEN	Lightweight: Organdy, Lawn, Calico	Cotton #80	90 (14) for general sewing 75 (11) for light-weight fabrics
	Heavyweight Oxford, Denim, Corduroy	Polyester #60 - 50 Cotton #60	
WOOL	Lightweight: Tropical, Wool, Poplin	Polyester #80 Cotton #60	
	Mediumweight: Gabardine, Flannel	Polyester #80-60 Cotton #60	
	Heavyweight: Velours, Camelhair	Polyester #60-50 Cotton #60	
SYNTHETIC FIBER	Lightweight: Georgette, Crepe, Voile	Polyester #100-80 Cotton #120-80	
	Heavyweight: Taffeta, Twills, Denim	Polyester #60 Cotton #60	
KNIT	Tricot	Polyester #80-60 Cotton #80-60	
	Jersey, Interlock	Polyester #60-50 Cotton #60	
	Wool	Polyester #60-50 Wooly Nylon	

SECTION II - THREADING & TENSION



Preparation for Threading

Spool Holders
For large cones of thread, use the black plastic cone holders. This will help hold the cone of thread in place.

Spool Caps
When using small spools, remove the plastic cone-spool holders (a drop of oil will make the holder slide off easily), and place the spool directly on the spool pin. Use the spool cap to keep the spool in place and to prevent the thread from catching on edges of the spool.

Spool Nets
Spools of specialty thread sometimes work loose from the spool during sewing, causing tangling or irregular thread feeding. To prevent this use the spool net provided as shown.

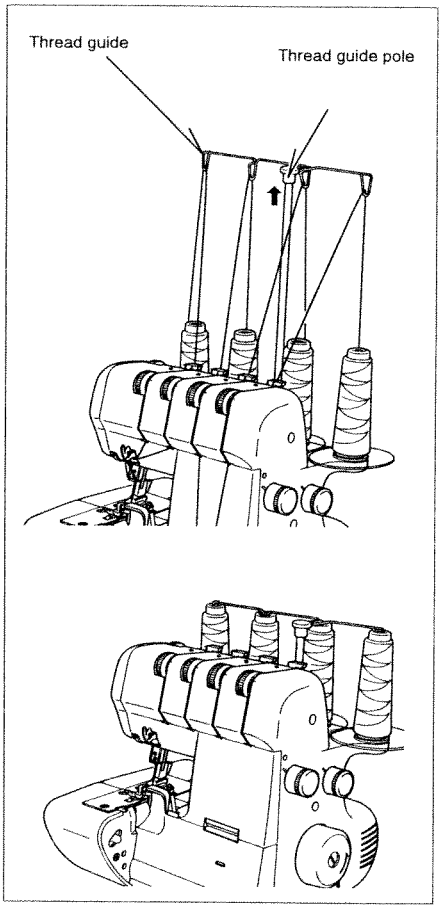
NOTE: Specialty threads, such as fine perle cotton, Designer 6 by YLI®, Ribbon Floss®, and Pearl Crown Rayon® by YLI may be used in the loopers of your Superlock. For successful stitching be sure these threads feed off their spools or skeins easily.

Your White Superlock is very easy to thread. With some practice you will be able to thread it in a few minutes without using any tools. Master the correct threading before starting your first project.

To become familiar with your Superlock, practice on scrap fabric with different color threads to identify placement and function of each thread.

Threading must be carried out in the following sequence for total ease of operation: upper looper - lower Looper - right needle - left needle.

Extend the thread pole to its highest point, then turn it until the shaft clicks into its locked position. Place threads on spools and draw ends through the guides from rear to front.



Your Instruction Manual shows threading the lower looper first. We have found that threading your upper looper first is easier and will allow your threads to lay in the correct order for a proper stitch.

THREADING UPPER LOOPER

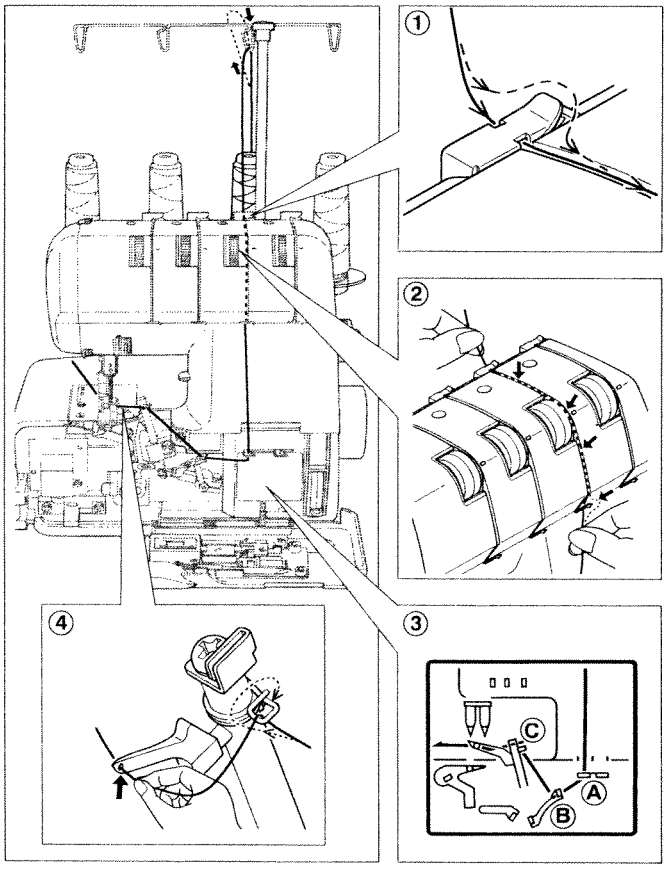
Open front covers.

Bring the upper looper to its lowest position by turning the handwheel toward you

Draw thread from spool and pass it through the thread stand (back to front), under thread clip guide (1) and then, in order, through guides 2-4 as illustrated below and inside the front cover of your Superlock.

With the presser foot raised to release tension, lay thread between thread tension discs. (2) Be sure thread is all the way into the tension discs. Snap thread into guide A, B, and C (illustration 3), then thread the hole of the upper looper (4) using the tweezers provided if necessary.

Bring thread tail under foot and toward back left corner of your Superlock.



THREADING LOWER LOOPER

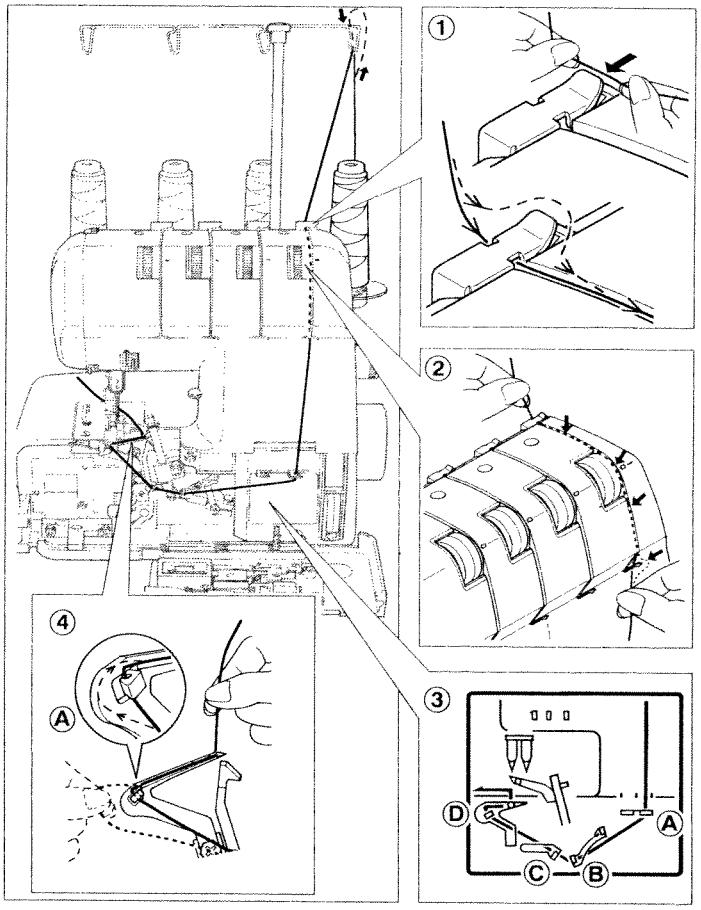
Bring the thread from the spool through thread guide back to front of the thread stand under (1) and then, in order, through guides 2-4 as illustrated below and inside front cover of your Superlock.

With the presser foot raised to release tension, lay thread between thread tension discs. Be sure thread is seeded all the way into the tension discs.

Bring the lower looper to the far left position by turning the handwheel toward you. Snap thread into thread guides A, B, and C (illustration 3), then hook the thread guide onto the lower looper thread guide D (Figure 3).

Then move the lower looper slightly to the right by turning the handwheel toward you. Thread the eye of the lower looper D (Illustration 3). You may wish to use the tweezers provided.

Bring thread tail under foot and toward the back left corner of the Superlock.



THREADING NEEDLES

Raise the needles to their highest position.

Bring the thread from the spool and pass it through the guides on thread stand (back to front), then under thread clip (1).

Lay thread between thread tension discs (2). Be sure thread is seeded all the way into the tension discs.

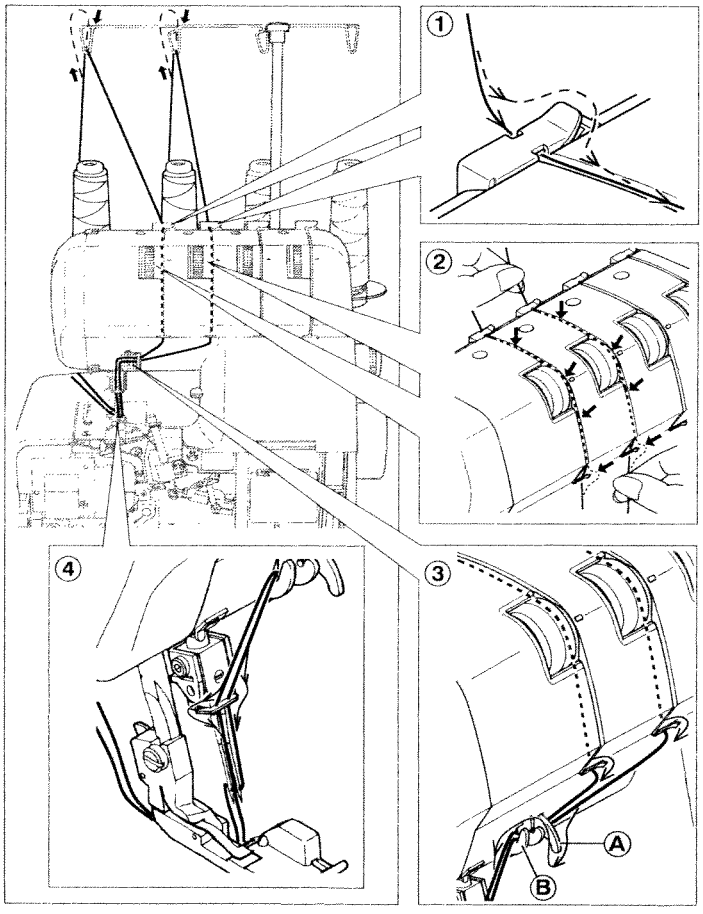
Pass thread through guides A and B for each needle.

Thread each needle(s) eye (4) using your needle threader found in the storage area of the right front cover.

To thread right needle, lower presser foot and raise needles to their highest position. Follow illustrations 1-6 (next page) inserting left peg of needle threader into hole on right side of needle bar, then sliding wire of needle threader through eye of needle (back to front).

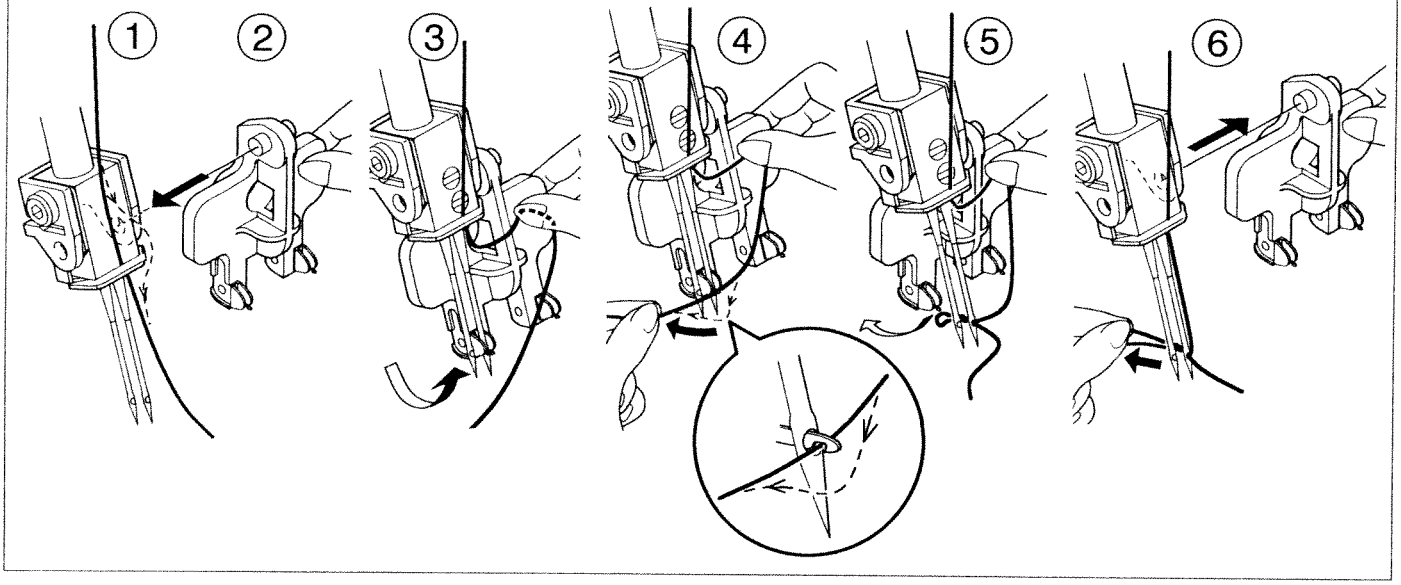
Hook thread under wire hook an dull needle threader straight back to pull thread through eye of needle. Place thread tail under presser foot and toward back left corner.

Thread left needle in same manner, following illustration Slide right peg of needle threader into slot on left side of needle bar and continue same as for right needle. Be sure to put needle threader back into the built-in accessory compartment.

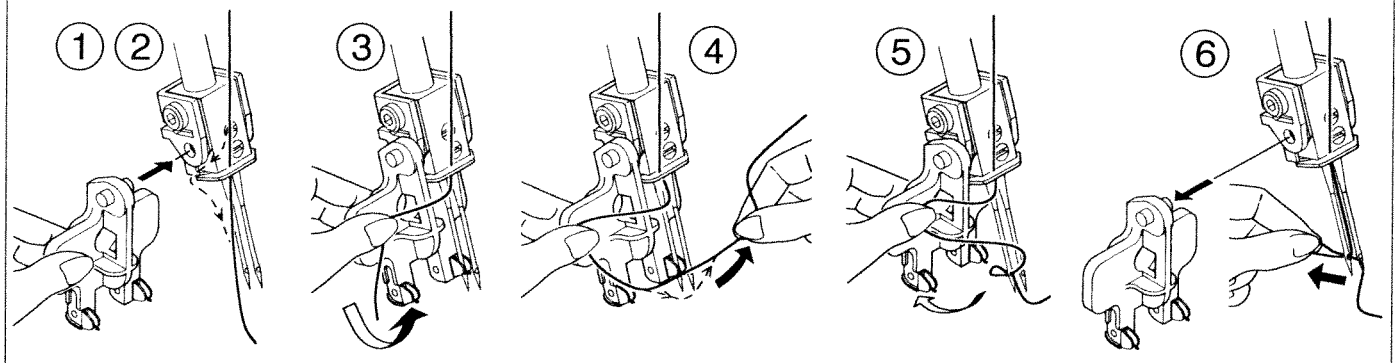


NEEDLE THREADER

(For right needle)



(For left needle)



HELPFUL HINTS - CHANGING THREAD

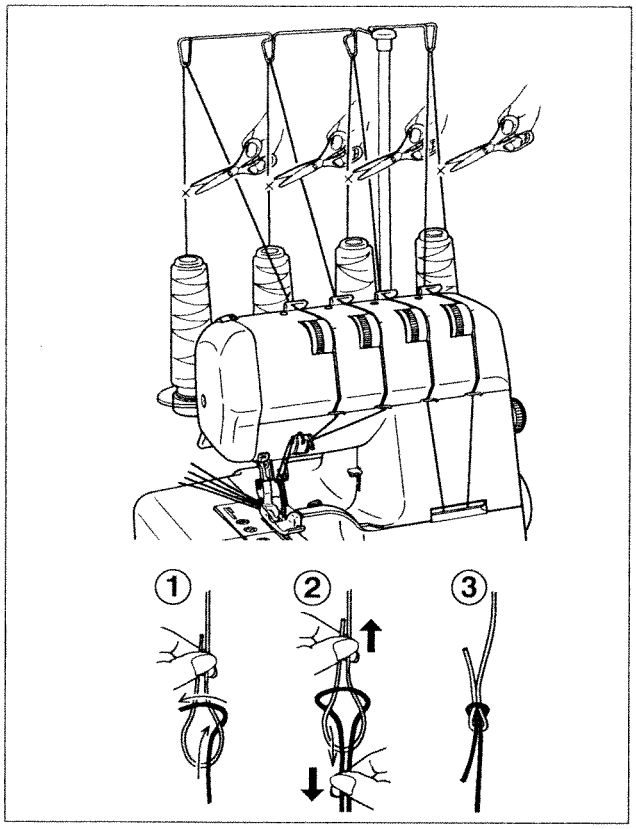
The following steps may be helpful when changing your threads.

•Cut off threads that are on your Superlock near the spools and replace the spools with new ones. Tie new thread on to old threads with overhand or square knot.

•Raise presser foot and cut the needle thread(s) right above the needle eye.

•Lower needle bar to its lowest position by turning the handwheel. With the presser foot in the highest position, pull the looper threads until the knots are about 4" past the presser foot.

•Rethread your needle(s).



TESTING STITCH

After threading is completed, test your Superlock stitch in the following order:

1. Be sure both front cover and side cover are closed.

2. Without fabric under the presser foot, lower presser foot. Pull the ends of the threads gently with your left hand toward the rear of the machine, turning the handwheel toward you a few times to make sure the stitch forms on the stitch finger (figure 1).

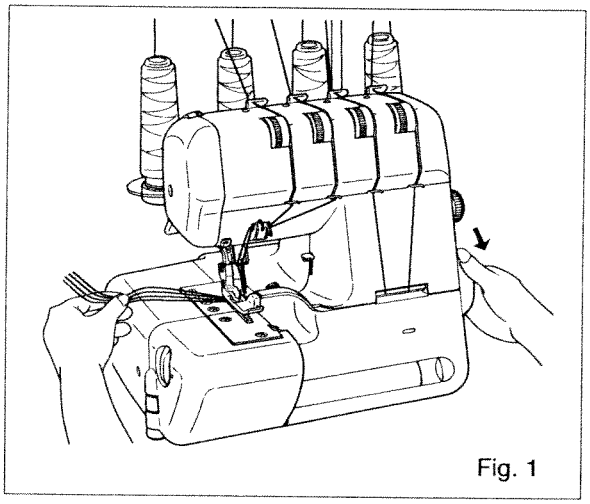


Fig. 1

3. Sew on scrap fabric. When you reach the end of the fabric, raise the presser foot and remove fabric from your Superlock. Use the handy thread cutter (figure 3) on your Superlock to cut your threads. Use the illustrations on the following pages to check the stitch formation produced to see if it is uniform. If not, you will need to adjust tensions and/or recheck threading.

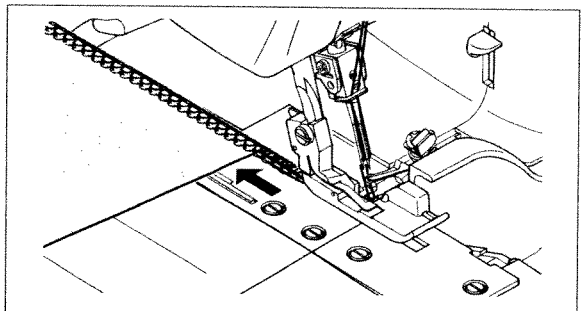


Fig. 2

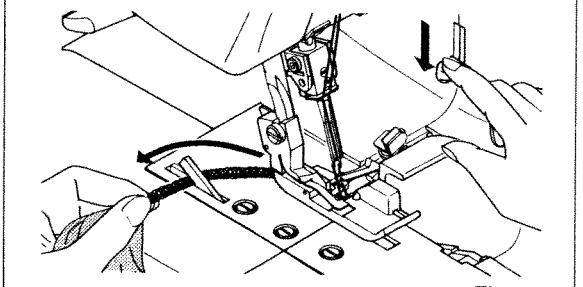


Fig. 3

THREAD TENSIONS

Thread tensions will vary according to the type and thickness of your thread and fabric. In most cases these tensions will only vary slightly. Turning the tension dial to a lower number gives you less tension. Threading your Superlock with four different colors of thread will help you identify the placement and function of each thread.

Upper Looper Thread should be flat on the top side of fabric and lock with the lower looper thread on the edge.

Lower Looper Thread should be flat on the underside of fabric and lock with the upper looper thread on the edge.

The needle threads should lay mainly on the top side like rows of normal straight sewing. The left needle will form a line of sewing along the left edge connecting the two looper threads and the right needle acts as a "safety stitch" forming a line of stitching through the upper looper thread.

Set your Superlock according to the tensions recommended below. Try test sewing on a piece of medium weight fabric. If you need to change the tensions mark them down for future reference.

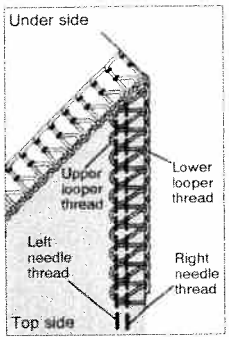
Left Needle (LN) __4__
Right Needle (RN) __4__
Upper Looper (UL) __4__
Lower Looper (LL) __4__

We will refer to these tensions as normal.

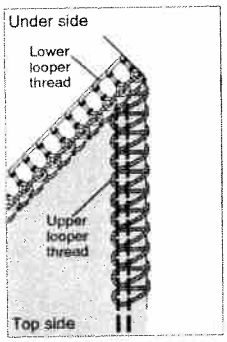
These tension recommendations are for average strength thread tension. It may be necessary to adjust the thread tension(s) slightly as different weights of fabric and thread can make a difference. Your tensions should remain in the outlined area on the tension dial.

ADJUSTING THREAD TENSION

Just Right

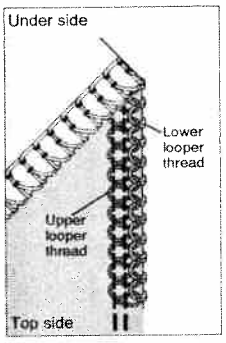


Upper Looper Thread Pulled to the Underside



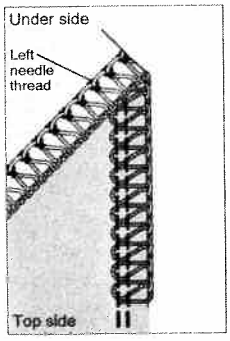
Increase upper looper thread tension and/or decrease lower looper tension.

Lower Looper Thread Pulled to the Top Side



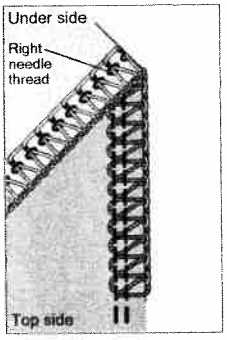
Increase lower looper thread tension and/or decrease upper looper tension.

Left Needle Thread Loose and visible on underside of fabric.



Increase left needle tension and/or decrease both loopers.

Right Needle Thread Loose and visible on underside of fabric.



Increase right needle thread tension.

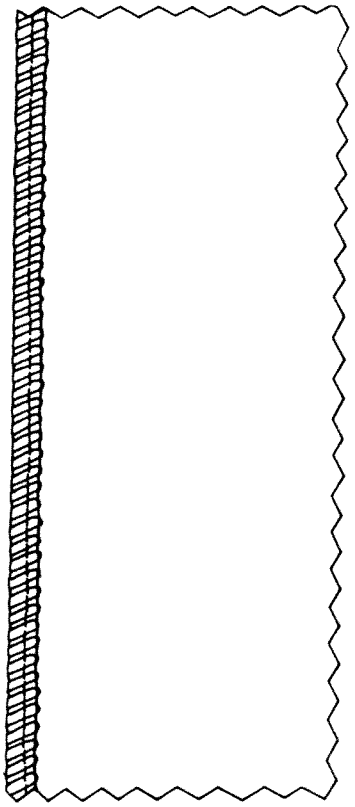
SECTION III

BASIC SEWING TECHNIQUES

Sew samples for the next section of this workbook, and record your tension settings on each page for future reference.

SUPERLOCK SEAMS & SEAM FINISH

Seam and overcast all in one step. Your Superlock produces fast, professionally-finished garments.



Machine Setting
Stitch Length: 2-3

Stitch width: 6

Fabric
Medium weight woven

Tension Setting
Set your tension to normal setting and note.

Left needle (LN) - 4 - _____
Right needle (RN)-4- _____
Upper looper (UL)-4- _____
Lower looper (LL)-4- _____

To Seam & Overcast

- •Fold fabric in half.
- •Place under presser foot with folded edge to be trimmed to the right.
- •Use your 5/8" seam allowance as a guide.
- •Serge seam.
- •Lift the presser foot , and pull your sample away. And cut the threads using the thread cutter.

To overcast raw edges for conventional seaming - Serge one edge of above sample to finish raw edge. Mount your sample on the facing page.

ADJUSTING STITCH LENGTH

Turn the stitch length dial (located on the right side of your Superlock) until the required length is at the guideline. The higher the number, the longer the stitch. With the dial you can adjust the stitch length from R for rolled edge to 5mm.

Stitch Length Sample

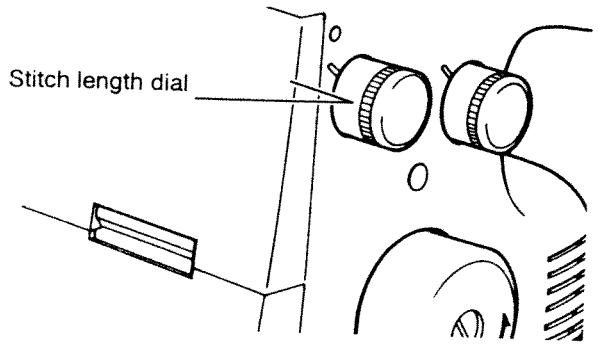
Machine Settings

Stitch length: 1 - 5 (see illustration)
Stitch width: 6

Fabric Medium weight woven

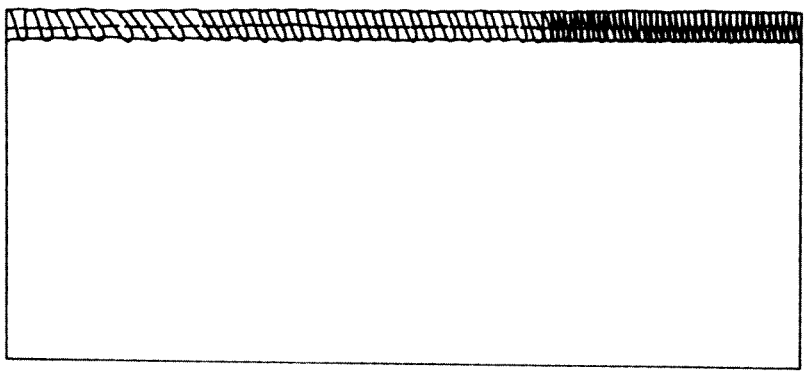
Tension Settings

Normal	LN	- 4 -	_____
	RN	- 4 -	_____
	UL	- 4 -	_____
	LL	- 4 -	_____



Serge

- Fold fabric in half.
- Set stitch length to 5mm.
- Stitch along edge stopping every inch and decreasing stitch length to 4, then 3, etc.

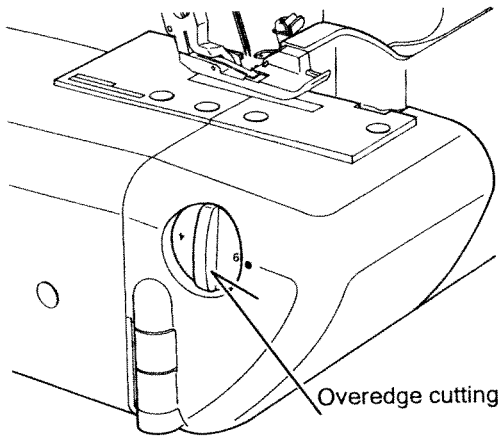


ADJUSTING CUTTING WIDTH & BALANCE OF STITCH

The cutting width can be adjusted from 4mm to 7mm by simply turning the cutting width dial according to the type of fabric you are working with. This fine tune adjustment allows you to achieve the best stitch possible on all fabric types.

The normal setting for the cutting width is 6mm.

Adjust the cutting width by turning the dial on the left side of the Superlock. If the cutting width is narrower than the stitch width, leaving loops off the edge of the fabric, turn the cutting width adjustment dial toward 7.



If the cutting width is wider than the stitch width causing a pucker within the overlock seam, turn the cutting width adjustment dial toward 4.

ADJUSTING CUTTING WIDTH

The cutting width can be changed for different techniques and types of fabric. Loosely woven or heavy knit fabrics require a wider width and lighter weight fabrics require a narrower seam width.

Machine Settings

Stitch length: 2.5 - 3.0
Stitch width: 6

Fabric

Medium weight woven

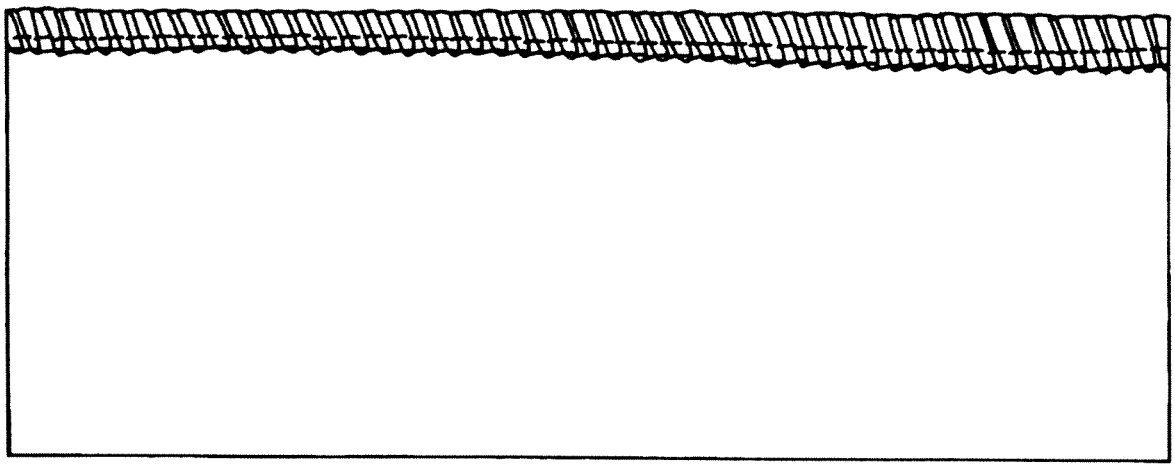
Tension Settings

Normal

Serge

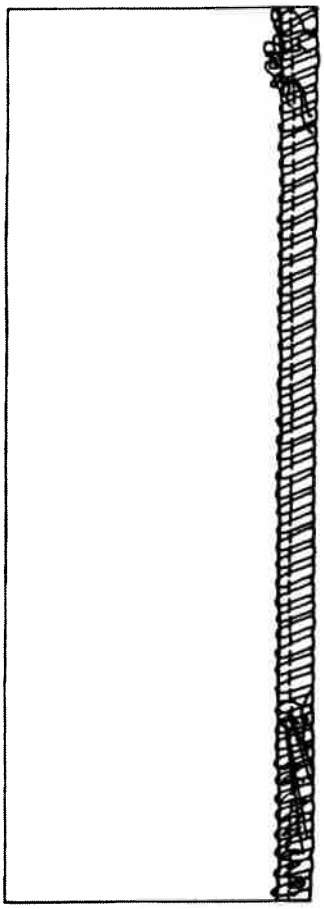
Serge along one edge with the stitch width on 4mm. Serge along the other edge with the stitch width at 7mm.

For a narrow or wide stitch width, see three thread sewing techniques on pages 38 and 39.



SECURING BEGINNING & END OF SEAM

As most ends of seams and finished edges are later stitched over during garment construction, it is often not necessary to lock ends. When needed, use one of the following methods.



Machine Settings
Stitch Length 2.5 - 3
Stitch width 6

Fabric
Medium weight woven

Tension Settings
Normal
(LN) - 4 -
(RN) - 4 -
(UL) - 4 -
(LL) - 4 -

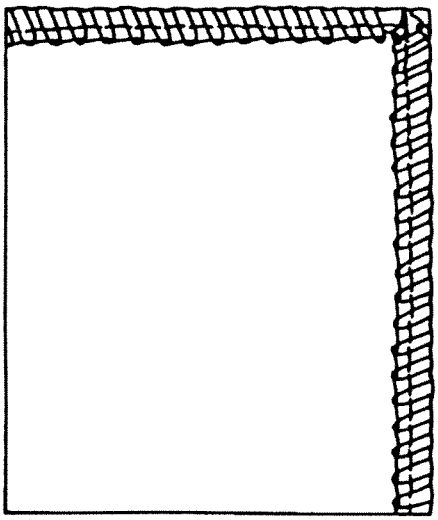
Securing Beginning of Seam
•Fold fabric in half
•Stitch 2-3 stitches into fabric, then stop sewing.
•Raise presser foot. Bring chain around left side of foot and under front of cutter.
•Lower presser foot and sew, cutting off excess chain.

Securing End of Seam
•Sew to end of fabric.
•Raise presser foot to release thread tensions and pull fabric 1" from foot.
•Reinsert fabric under foot about 1" from end and serge over previous stitching.
•Raise presser foot and pull sample out.
Use thread cutter to cut threads.

Optional Securing Methods
•You may tie a knot in the thread ends. This method requires about three inches of extra thread. After tying knot, trim ends.
•Use a small amount of Fray Check™ at the ends.
•Thread ends into the finished seam. This requires one or two inches of thread at the end and is usually the best choice for decorative finishes.

OUTSIDE CORNERS

You can stitch neat outside corners with little practice on your Superlock.



Machine Settings
Stitch Length: 2.5 - 3.0
Stitch Width: 6

Fabric
Medium weight woven

Tension Settings
Normal
(LN) -4-
(RN) -4-
(UL) -4-
(LL) -4-

Serge (Sew along edge of fabric; do not trim.)
•Sew along one side of fabric to the end.
•Raise the needles and presser foot.
•Gently slide the threads off the stitch finger of the needle plate by pulling fabric toward back of Superlock.
•Grasp the fabric gently and turn the corner.
•Realign the edge of the fabric and put the cut edge of the fabric against the cutter.
•Pull up slack in threads.
•Lower presser foot.
•Serge the edge. Repeat for the remaining corners.

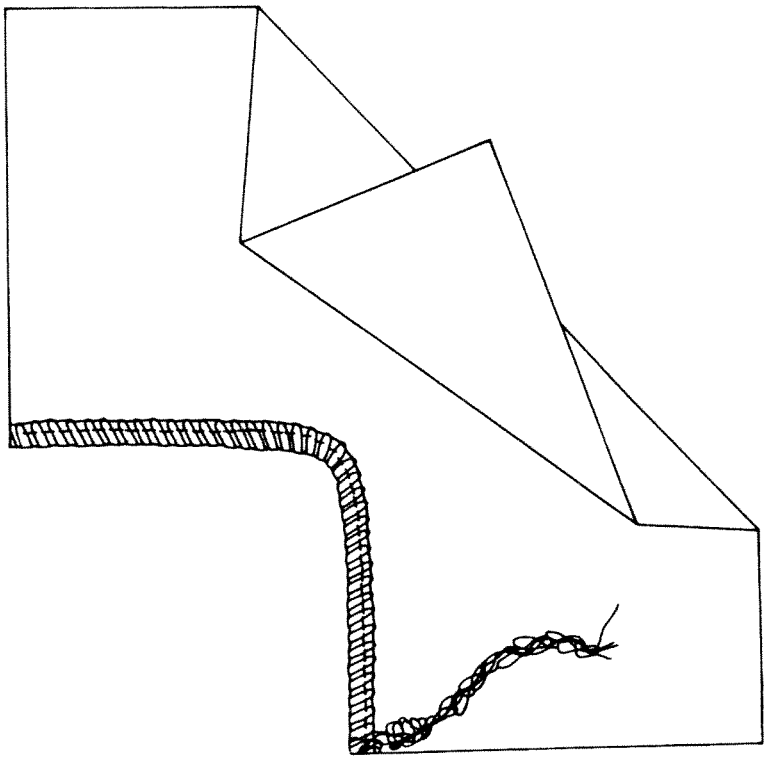
INSIDE CORNERS

Practice the inside corner technique for perfect inside corners or curves such as for Christmas stockings, oven mitts or kick pleats on skirts.

Machine Settings
Stitch Length: 2.5 - 3
Stitch Width: 6

Fabric
Medium weight woven
(Cut a square out of one corner.)

Tension Settings
Normal
(LN) -4-
(RN) -4-
(UL) -4-
(LL) -4-



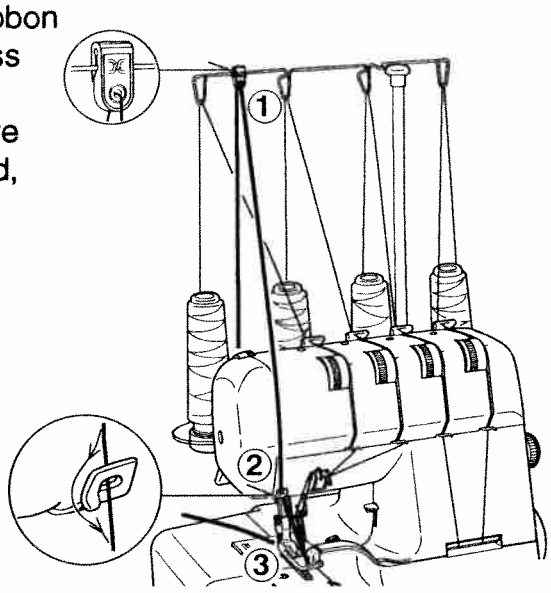
Serge
•Align the edge with the inside edge of cutter, with bulk of fabric to the left.
•Serge up to 1/2" from the inside corner.
•Careful! Your cutter is 1/2" in front of the needle so you must fold fabric away from the cutter before the corner reaches it.
•Pull fabric into a straight line and align the unfolded edge against the inside edge of the cutter. There will be some tucks in the edge. These should lay flat after stitching.
•Continue to serge along the edge.

Sleeve Placket
•Cut a 2 1/2" slit in a second piece of fabric.
•Cut a strip of fabric 1" x 5".
•Fold strip in half lengthwise, wrong sides together.
•Lay strip on slit right sides together.
•Using inside corner technique, stitch strip to opening forming a placket.

CORDED OVERLOCK

The Specialty Technique Guide consists of the snap on cord guide (1) found in your accessory pouch, the guide above the needles (2) and either hole in the presser foot (3).

The Specialty Technique Guide guides cord through the foot and then is covered by the upper looper thread or is caught by the right needle, depending on the size of cord you choose. Ribbon or Cording can be used to stabilize where stress occurs: joining shoulder seams, sleeves, side seams, etc. You can also use it for a decorative look in the areas that are visible. Use filler cord, perle cotton, twill tape, gimp, wool yarn, elastic thread, polyester ribbon, etc.

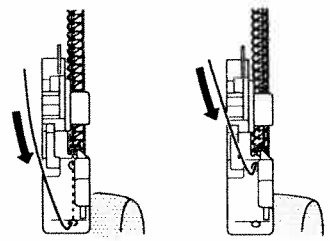


Machine Setting
Stitch Length: 2.5 - 3
Stitch width: 6

Fabric
Sweatshirt Fleece & 1/8" - 3/16" Ribbon

Tension Settings
Normal

(LN)	- 4 -
(RN)	- 4 -
(UL)	- 4 -
(LL)	- 4 -



•Feed ribbon through guides and front hole on foot. Slide ribbon under foot to needles.
•Fold fabric in half.
•Serge with four thread seam to stabilize seam.
•Use the back hole in foot for cording, fishline, etc.

RIBBING

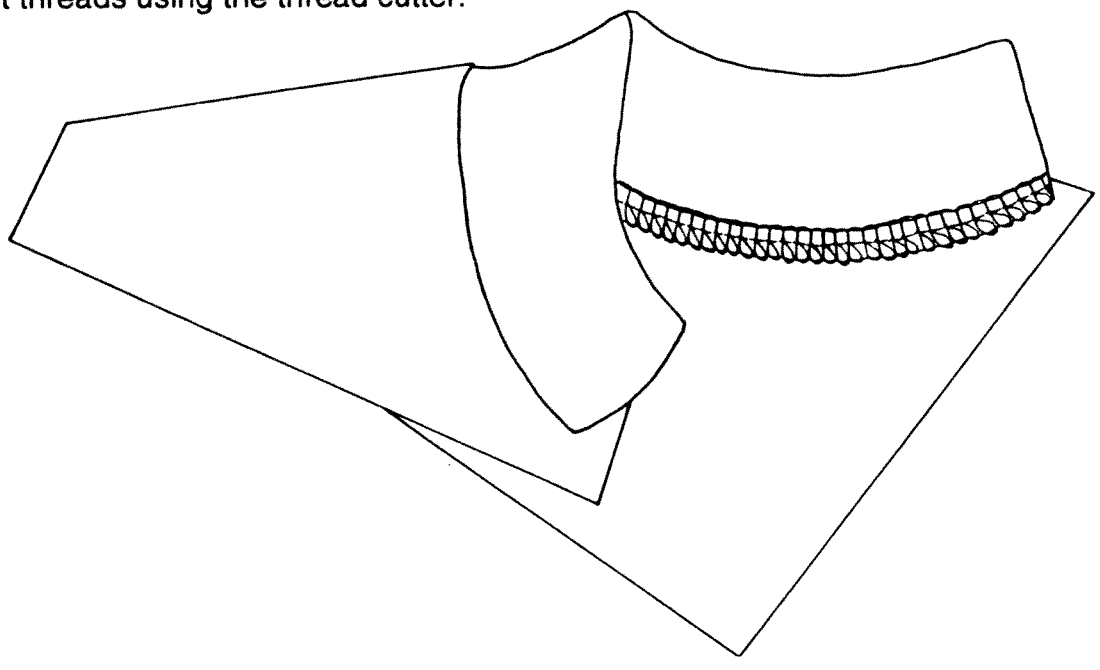
Your Superlock will finish, trim and allow the material to stretch while retaining its original shape.

Machine Setting
Stitch Length: 2.5 - 3
Stitch Width: 6

Fabric
Sweatshirt fleece and ribbing

Tension Settings
Normal
(LN) -4-
(RN) -4-
(UL) -4-
(LL) -4-

Serge
•Cut a curved neckline in fabric.
•Fold ribbing in half lengthwise.
•Place ribbing on neckline with raw edges even.
•Serge, stretching ribbing to meet neck edge.
•When attaching ribbing in a circle such as around the neck, serge around until your stitches overlap one inch. Raise the presser foot and pull your work out, and cut threads using the thread cutter.



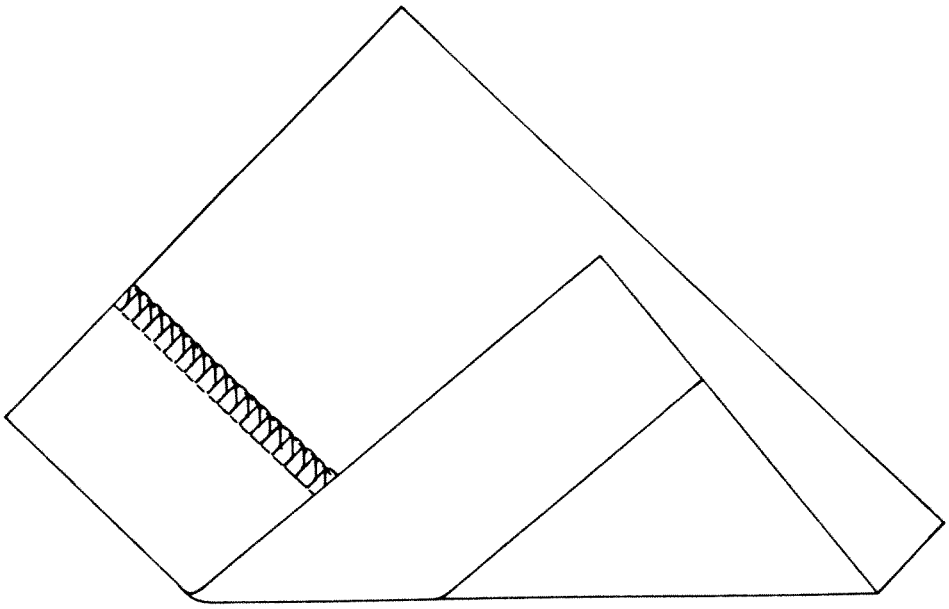
CASING OR HEM FOLD

Try this easy technique for T-shirt hems, elastic and drawstring waistbands or curtain rod casings.

Machine Setting
Stitch Length: 2.5 - 3
Stitch Width: 6

Fabric
Medium weight woven

Tension Settings
Normal
(LN) - 4 -
(RN) - 4 -
(UL) - 4 -
(LL) - 4 -



Serge
•Measure and fold the desired depth for the casing.
•Hold the folded fabric with wrong side facing you.
•Turn the casing underneath so that the fabric now has an "S" shape.
•Serge along the fold with the wrong side up catching both needles into fold of fabric.